

Work Order ID 116591-2

April-22-14 7:25:08 AM

116591

Ship 25 April

Page 1

Item ID: D4923-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 4/22/14 Start Qty: 16.00

Required Date: 4/25/14 Req'd Qty: 16.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MLS

Date: 14-04-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4923

A

110

110

Waterjet

FLOW CNC Waterjet

304.063"

FLOW WATER JET

Memo

1-Cut D4923-1 as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

0.00

16 0 Jm 14-04-22

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

16 0 Jm 14-04-22

130

130

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

14/4/22

16 0

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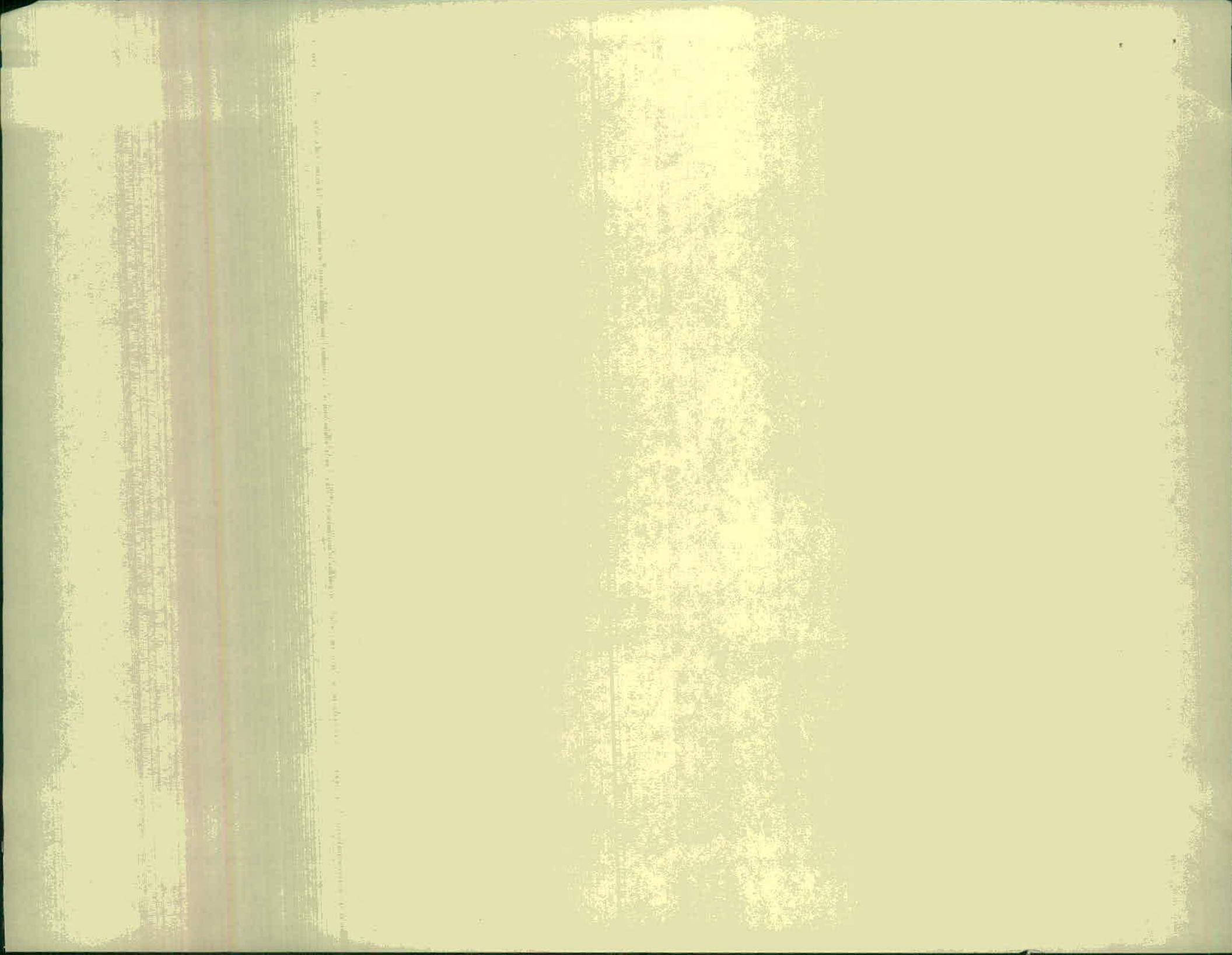
116591

Page 2

Item ID: D4923-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 4/22/14 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 4/25/14 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00		DAS 30 9-89		<u>6</u>			14/04/22
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>K6</u>			
160 *160* Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch: <u>M120854</u> Large Fab Memo WELD BAR ON PLATE AS PER DWG	0.00 0.00				<u>(x16)</u>	<u>me/MAL</u>	<u>14.04.24</u>	



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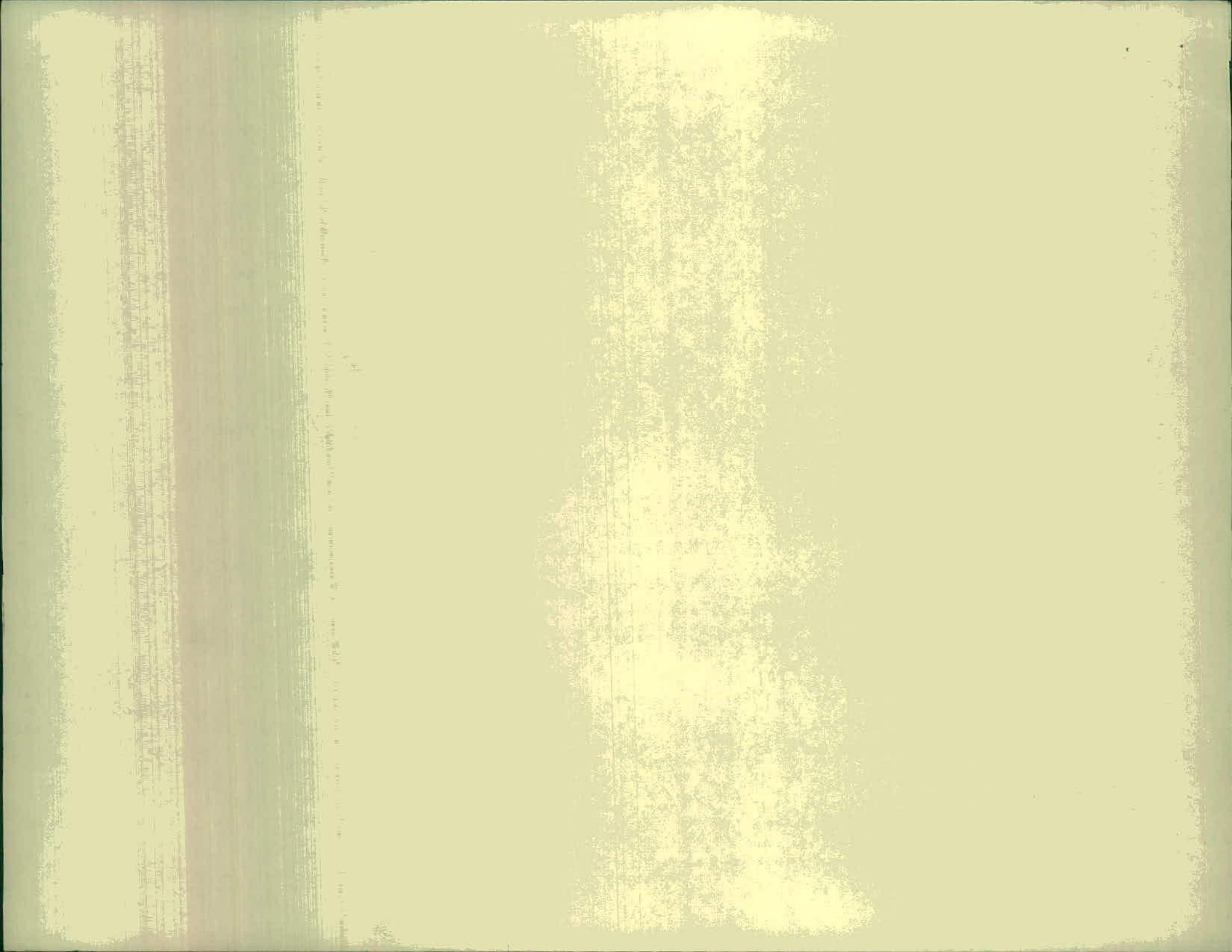
Page 3

Item ID: D4923-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 4/22/14 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 4/25/14 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
240	Identify as per dwg & Stock Location: PPP	0.00							
240	Packaging 117790								
Packaging	Memo	0.00							
Packaging									

DAS
33
9-89



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Item ID: D4923-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 4/22/14 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 4/25/14 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							
Quality Control									

14/5/14
14.05.00

Picklist Print

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Work Order ID: 116591

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Parent Item: D4923-041

D4923-041

Parent Item Name: Wearplate Assembly

Start Date: 4/22/14

Required Date: 4/25/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 13.09.06 new issue DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4932-1-035		Manufactured	No				Each	0.0000		16			
D4932-1-035									**	(x16)		31-2	14-04-24
KWS Carbide Wear Strip, 3.5" Long													
M304S16GA		Purchased	No				sf	154.2670		(3)			
M304S16GA									**				Jm14-04-22
304/316 Sheet .063													

Location

Loc Qty

Loc Code

MAT020

164.267

M126915

1.487

M127821

122.53

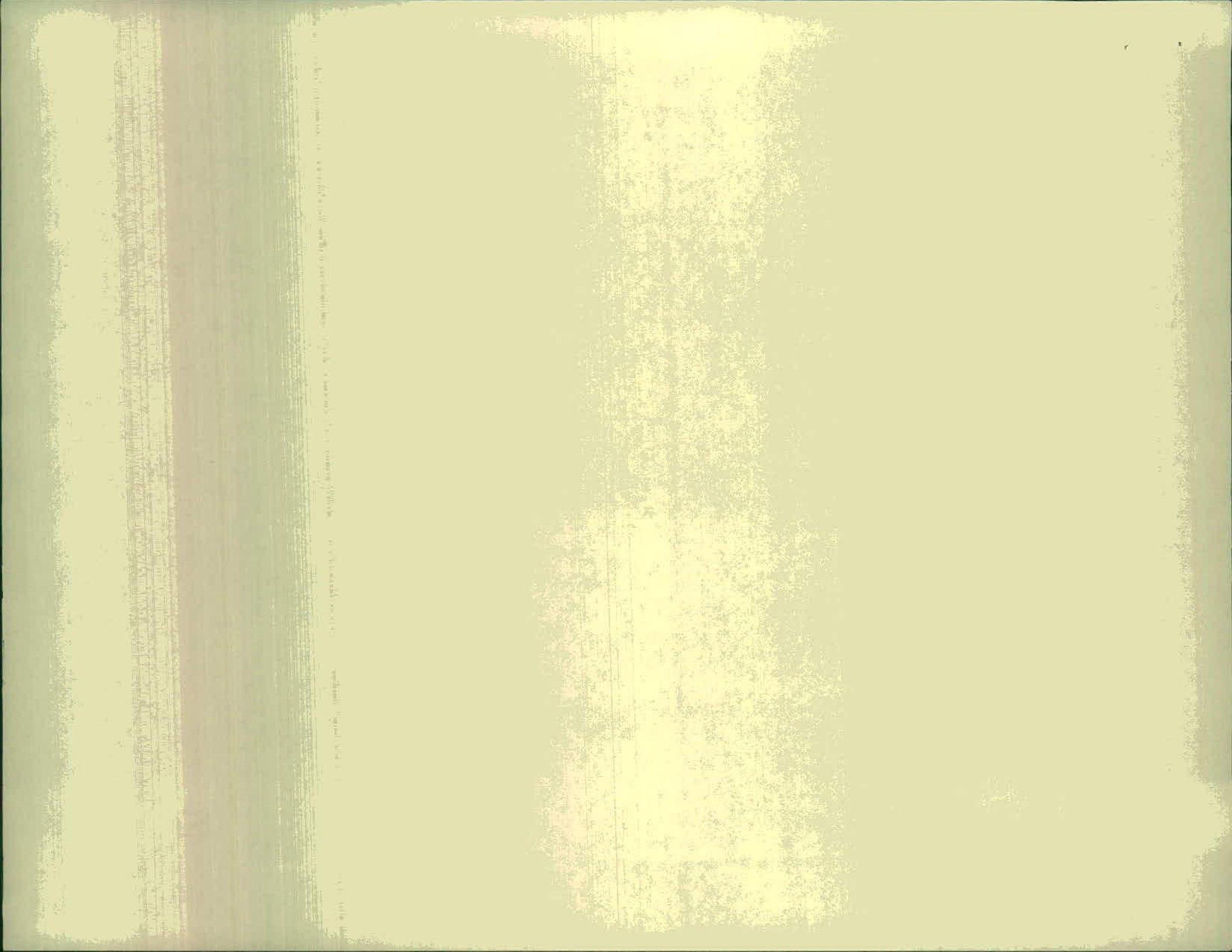
M128054

31.89

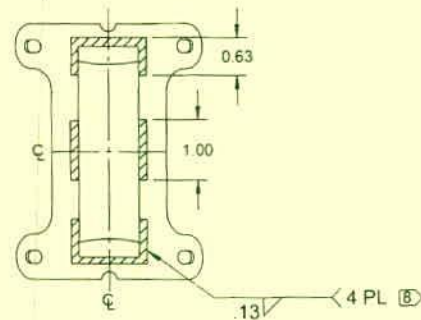
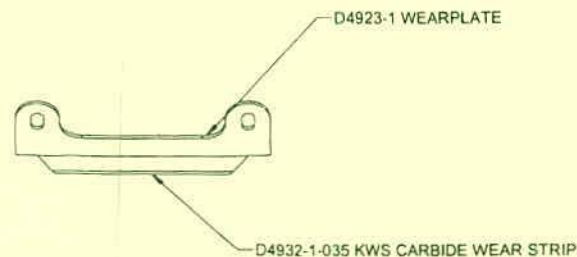
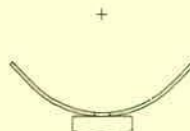
M128423

8.36

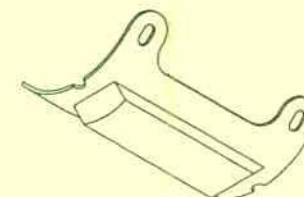
128054.



ITEM	QTY -041	P/N	DESCRIPTION
	X	D4923-041	WEARPLATE ASSY
1	1	D4923-1	WEARPLATE
2	1	D4932-1-035	KWS CARBIDE WEAR STRIP



D4923-041 WEARPLATE ASSY



116591
MLJ
14-04-22

RELEASED
2014-04-08

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4923-041" PER QSI 044 METHOD 6.1
 - 7) WEIGHT: 0.63 lbs
 - 8) WELDING: PER QSI 004

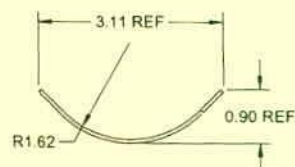
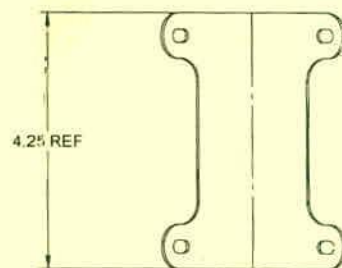
A	NEW ISSUE	BB	13.08.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	DE		
CHECKED	A.P.		
MFG. APPR.	DE		
APPROVED	DE		
DE APPR.	DE		
DATE	13.08.12		

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HAWKESBURY, ONTARIO, CANADA

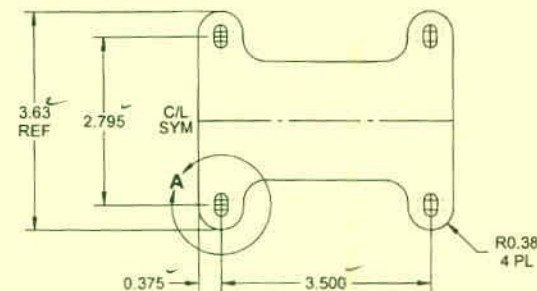
DRAWING NO. **D4923** REV. A
TITLE **WEARPLATE** SCALE NTS

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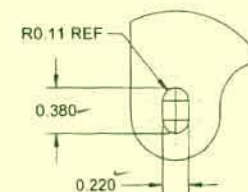
1870



D4923-1 WEARPLATE
MAKE FROM D4923-1F



D4923-1F FLAT PATTERN



DETAIL A
SCALE 2X
4 PL

RELEASED
2014-04-01

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513, AMS 5524, MIL-S-5059, ASTM240 OR ASME SA240 16 GAUGE (0.063 THICK), (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4923	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
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